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NEW PIPE-THREADING MACHINE DEVELOPED

Engr V. A. Yeletskiy

The Construction Tool Plant imeni M. I. Kalinin has designed and put into production a new-model machine tool for threading pipes of diameters up to 1½ inches.

The S-225 pipe-threading machine is intended primarily for cutting gas-pipe threads, but can also be used for cutting bolts, tension shackles and pins with diameters of 12 to 76 millimeters, either with inch or metrical threads.

The S-225 has a number of advantages over earlier threading machines for pipes up to 1½ inches, and other similar pipe-threading machines. Its specifications are as follows:

Maximum diameter of work-piece clamped in the vise	76	mm
Minimum diameter of work-piece clamped in the vise	14	mm
Maximum pitch of thread that can be cut	2.5	mm
Number of different spindle speeds	4	
Number of spindle revolutions (rpm)	40; 65; 83; 134	
Diameter of internal aperture of block	77	mm
Number of cutting dies in block	4	
Maximum length of cut	200	mm
Maximum carriage travel	260	mm
Motor power	2.2	kw
Motor speed (rpm)	1,500	
Dimensions of machine	1,425 x 700 x 1,160	mm
Weight	700	kg

1. The machine has four spindle speeds corresponding to modern cutting speeds of threading.

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2. The spindle and all transmission shafts are mounted on roller bearings, permitting regulation of tension for eliminating slack.

3. Central control of the gripping jaws and their design and construction have been improved and considerably simplified in the machine.

4. The motor used has standard rpm. This motor is in serial production.

5. The machine is comparatively cheap to manufacture, is simple and easy to repair, and appears well designed.

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